

Date: Friday, 18/07/2008 10:50:31 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STRUT
<b>Job Number</b> : 40617	
<b>Estimate Number</b> : 10204	
<b>P.O. Number</b> :	<b>Part Number</b> : D21997
<b>This Issue</b> : 18/07/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2199 REV. E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : E1
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/08/2008 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.7.18</u>	
<b>Comment</b> : Est:A 02.06.10 New Issue NG/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 1.3125 f(s)/Unit Total : 6.5625 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall  
 (M304TR0750W049)

Batch No: M107518 (3)

M108498 (2)

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15  
400 °F  
9:45

M. L 08/08/08

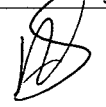
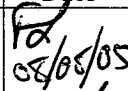
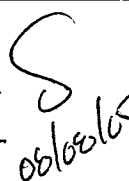


(5X)

(P2)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2195-7 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: D Date: 08/06/04  
D212-601-042 QA: N/C Closed: D Date: 08/08/08

NCR: <u>40617</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/5	5.0	Durkin Qc3 Powder coat inspection it was found on 2 parts that there was some die/markings that came through the powder coat. P.C. Parts were not cleaned enough.		Scuff with 320 grit sand paper till raw mat is showing.  clean with acetone  Re Powder coat as per QSTC05	 08/08/05  M-12 08/08/05  M-12 08/08/05	 08/08/05	 08/08/05	 8/8/5

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40617

Part Number: D21997

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FL 08/08/05* (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *272*

*8/8/5* (5x) *SD*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 08/06/08* (5)

Job Completion



*U 08.08.06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**DART AEROSPACE LTD  
HAMKESBURY, ONTARIO, CANADADESIGN  
CHECKED  
APPROVEDDRAWING NO.  
D2199REV. E  
SHEET 1 OF 1

DATE

98.04.28

TITLE

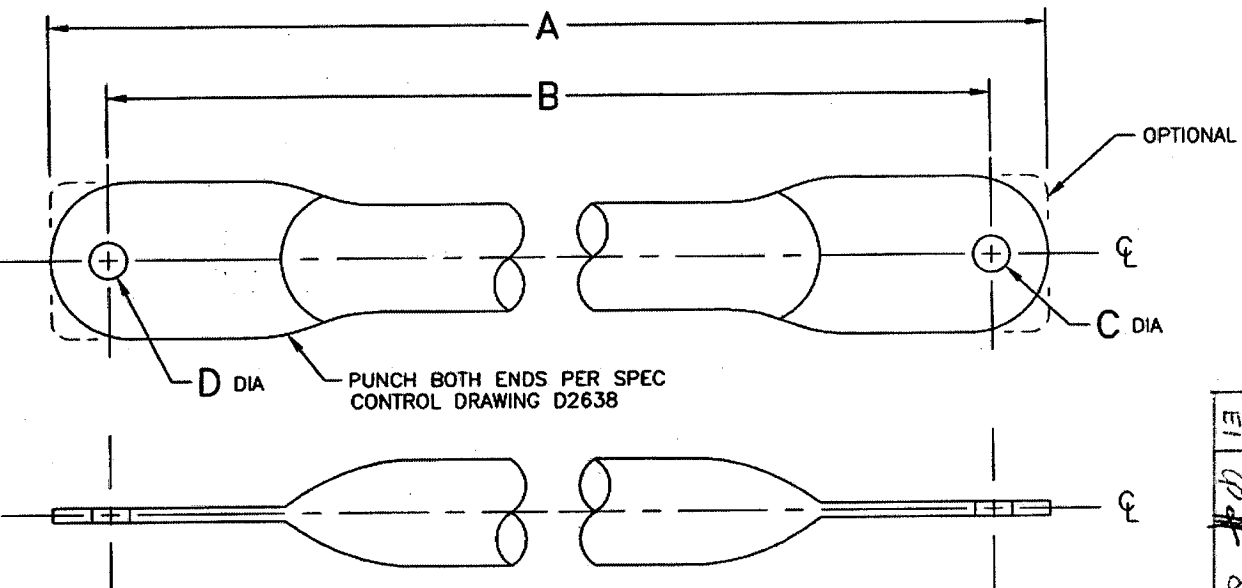
STRUT DETAILS

SCALE

NTS

RELEASED  
48.05.05 EE

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	02.03.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B B B C C C E E E

} 00.10.13  
{ 00.10.13

## NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT. WHITE (4.3.5.2) PER DART QSI 005 4.3/ET

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WITHOUT NOTICE

WORK ORDER

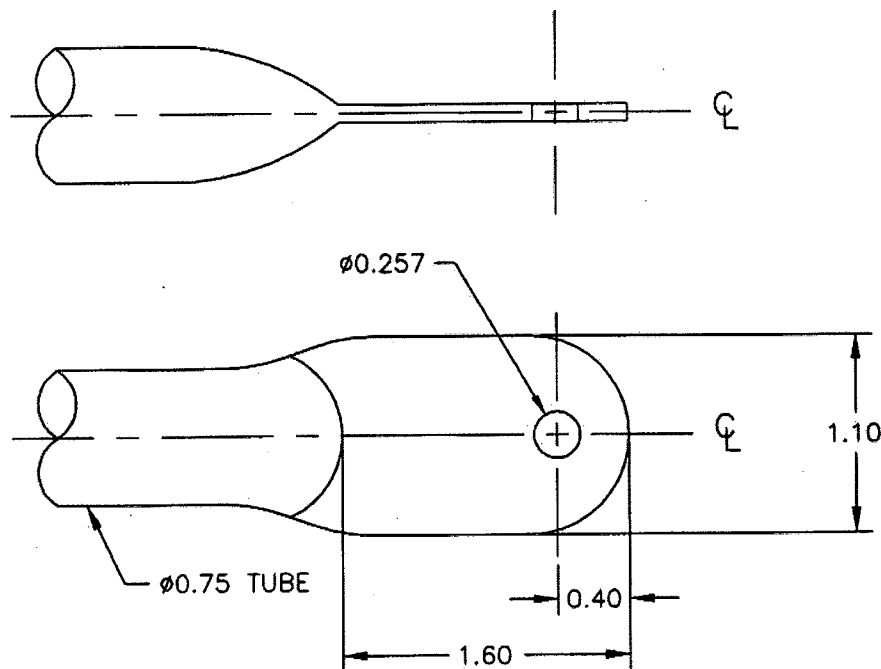
NO. 40617



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED  
98/09/05 KE

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8117



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